

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 74.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012846**Date Inspected:** 25-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Goodwin Steel, UK**Location:** Stoke-on-Trent, UK

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	Cable Band				

Summary of Items Observed:

The following report is based on METS observations at Goodwin Steel Castings, Stoke-on-Trent on this date:

The QA Inspector observed weld repairs in progress on Casting GG29441-2. Drawing Number 5540-B10-2-F. Mr. A. Barnett, Welder Number 59 was observed welding excavation number 5 on revision 4 of the Weld Excavation Map. Mr. Barnett was using WPS04-0120F4B Issue 4 which was available at the work station. The casting was preheated to 160 degrees C, and verified with a temp stick. Four (4) mm E7018-1 was being used and the rod quiver in use was warm to the touch.

The QA inspector received and completed a review of the document packages including the Certificate of Conformity for;

GG29437-2, Drawing 5540-B9-1-F; the documentation package appears to be complete and acceptable

The foundry operations are complete including Visual Inspection, Nondestructive Testing, Mechanical Testing, and casting repair.

The QA inspector reviewed radiographic film of casting GG29444-2, B13-2-M, and GG29445-2, B13-2-F with Goodwin Steel Castings NDT Level II technician Mr. Ian Pointon. The film quality and weld quality were reviewed for compliance with Goodwin Steel Castings Radiographic Inspection Procedure RT06-09-020 revision 2. No unacceptable indications were observed. Radiography of these castings was not 100%, only the areas that had previously failed radiography on GG29444-1, B13-2-M and GG29445-1, B13-2-F were radiographed. The

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

remainder of each of these castings requires ultrasonic testing as specified in ABF-RFI-002071R00.

Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Riegler,Randy	Quality Assurance Inspector
Reviewed By:	Edmondson,Fred	QA Reviewer
